



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2572

Job Sheet 170901



Part No: D2572

Job Qty: 6 ea

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/23/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 2/16/18

Type: SOLD

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/15/18	2/15/18	0.00	0.00	Start Up Machining		FK 18-2-1
100	CNC Vertical Machining	6 pcs	2/15/18	2/15/18	0.62	9.68	HAAS 1		FK/SBL 18/02/03
110	Mill Conv	6 pcs	2/15/18	2/15/18	0.00	1.00	Mill Conv 1		FK/SBL 18/02/03
120	QC	6 pcs	2/15/18	2/15/18	0.00	0.00	QC2		FK/SBL 18/02/03
130	QC	6 pcs	2/15/18	2/15/18	0.00	0.00	QC8		monk / 18/02/07
140	HandFinish	6 pcs	2/15/18	2/15/18	0.00	0.25	HandFinish1		18-02-07 ST
150	Powdercoat	6 pcs	2/16/18	2/16/18	0.00	0.23	Powdercoat1		BRP 18-02-08
160	QC	6 pcs	2/16/18	2/16/18	0.00	0.00	QC3		11 FEB 14 2018
170	Packaging	6 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3		9-09 FEB 14 2018
180	QC21-SA	6 Ea	2/16/18	2/16/18	0.00	0.00	QC21		21 FEB 14 2018

Part Op 100 - Program Batch No. Double check by: 1-Machine Step No 1 per Folio FA051 and inspect per Descriptions: attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp

110 - Machine keyway, as per dwg D2571 & D2572

150 - START TIME: 1:05

FINISH TIME: 1:35

OV.T: 300° M 138467

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	6 Ea (1 ea)	90-Start up Operation	FILE 4405 x 3 FILE 5017 x 3

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Inboard	0.257Inches	0.262		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-tube Machining Thermoforming Large Fab		AGAINST DEPARTMENT/PROCESS Change No: Operation: Revision: Original Serial #: PART NO: Saddle, Fwd, In S037858 D2572 Start up Operation 02/01/18 Job No: 170901	
Date :		Step #:		QTY Effect			
Description Work Order Deviation							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Def ☐ Inspection Incomplete ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete ☐ Drill Holes ☐		Misaligned/off center ☐	
OTHER :				Turning Sequence			

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 www.dartaerospace.com

			+ 0.005	0.257
			- 0.000	
8	Saddle, Fwd Inboard	0.375Inches	+ 0.005	0.380
			- 0.000	0.375
9	Saddle, Fwd Inboard	0.490Inches	+ 0.020	0.510
			- 0.000	0.490
10	Saddle, Fwd Inboard	1.174Inches	+ 0.010	1.184
			- 0.000	1.174
11	Saddle, Fwd Inboard	0.558Inches	+ 0.020	0.578
			- 0.000	0.558
12	Saddle, Fwd Inboard	1.174Inches	+ 0.010	1.184
			- 0.000	1.174
13	Saddle, Fwd Inboard	1.490Inches	+ 0.010	1.500
			- 0.000	1.490
14	Saddle, Fwd Inboard	2.495Inches	+ 0.010	2.505
			- 0.000	2.495
15	Saddle, Fwd Inboard	3.869Inches	+ 0.010	3.879
			- 0.000	3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020	0.198
			- 0.000	0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040	2.980
			- 0.000	2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020	0.250
			- 0.000	0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005	0.312
			- 0.000	0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005	0.765
			- 0.000	0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020	0.372
			- 0.000	0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060	0.530
			- 0.000	0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020	0.635
			- 0.000	0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020	0.073
			- 0.000	0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020	1.395
			- 0.000	1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040	0.280
			- 0.000	0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020	2.020
			- 0.000	2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020	0.043
			- 0.000	0.023

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

DART AEROSPACE LTD	Work Order: 170901
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	8.000	8.000		
F	0.490	0.510		.500	.499	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.499	.500	.500	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.126	.125	.126	.126		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.127	.127	.128	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.960	2.960	2.960		
V	0.230	0.250		.241	.243	.241	.241		
W	0.115	0.135		.127	.126	.127	.126		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.624	.623	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	.253	.251	.251		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject				✓	✓				

Measured by: FK / SBL
Date: 18-2-2 / 18/02/03

Audited by: 7774
Date: 18/02/07

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	170901
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#5	#6	3	4		
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.500	.500				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.174	1.174				
K	0.558	0.578		.564	.564				
L	1.174	1.184		1.174	1.174				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.873	3.873				
P	0.115	0.135		.130	.130				
Q	0.115	0.135		.126	.126				
R	0.240	0.260		.252	.252				
S	0.115	0.135		.125	.125				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.241	.240				
W	0.115	0.135		.130	.130				
X	0.307	0.312		.310	.310				
Y	0.760	0.765		.762	.762				
Z	0.352	0.372		.363	.363				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.626	.626				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.250	.250				
AH	0.240	0.260		.250	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: SBL
Date: 18/02/03

Audited by: anym
Date: 18/02/03

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	